

5/44

DART AEROSPACE LTD	Work Order:	24508
Description: 3" Outer Tube	Part Number:	D2600-1-160
Drawing: D2600 Rev. D1	Qty:	160

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveller	<i>[Signature]</i>	05.10.12	160
2	PG	Issue P/O: <u>2608805</u> a) Extrude as per Dwg D2600 b) Material: 6061-T6 (QQ-A-200/8) c) Minimum yield tensile strength = 35 ksi d) Minimum ultimate tensile strength = 40 ksi e) Minimum elongation = 8% f) Order at 160" long g) Bon L Canada Inc. tool # 897121 h) To be packed per DSK 066 i) Pull test to ASTM standard B221 required. j) Material certification is required	<i>[Signature]</i>	05/10/12	160
3	RG	Inspect for transit damage Ensure certification are attached	<i>[Signature]</i>	05/11/12	171
4	QC6	Inspect dimensions per Dwg D2600 Check Pull test per Dwg D2600 for compliance page attached. Check hardness with Webster tester	<i>[Signature]</i>	05.12.12 ²¹	171
5	ST	Identify and Stock	<i>[Signature]</i>	05.12.12 ²¹	171
6	AC	Cost / part	<i>[Signature]</i>	05.12.21	171
7	DC	Close W/O Inspect Level 21	<i>[Signature]</i>	05/12/21	171

Rev	Date	Change	Revised By	Approved
A	99.09.15	New Issue, was D2600-1-150, changed to -160	EC	
B	00.05.08	Removed second pull test & tool #	EC	
C	01.04.16	Removed second pull test & tool #	EC	
D	02.09.05	Added DSK 066	KJ RF	<i>[Signature]</i>

RELEASED
02/09/17 RF

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: JD Date: 05/12/21

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2600	REV. D SHEET 1 OF 5
DATE 98.08.20		TITLE EXTRUSION	SCALE 1:1
A	97.01.21	NEW ISSUE	
B	97.09.09	CHANGE MATERIAL SPEC.	
C	98.04.16	ADD D2600-3, UPDATE D2600-1 WIDTH, ADD DIE NO.	
D	98.08.20	INCREASE MIN. UTS TO 40 KSI	
DI	01.04.17	ADD PART NUMBERS & DIE NUMBERS <i>4 GP</i>	

RELEASED
98.08.25 DS

GENERAL NOTES

1. MATERIAL: 6061-T6 (QQ-A-200/8)

MINIMUM YIELD TENSILE STRENGTH = 35 ksi
MINIMUM ULTIMATE TENSILE STRENGTH = 40 ksi
MINIMUM ELONGATION = 8 %

A SAMPLE FROM EACH BATCH WILL BE PULL TESTED
TO ASTM STANDARD B221 BY AN APPROVED TESTING
FACILITY TO ENSURE THAT THE BATCH MEETS THE
ABOVE MINIMUM MECHANICAL PROPERTIES.

2. BREAK ALL SHARP CORNERS 0.010 MAX.
3. NO TOOLING MARKS.
4. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE
NOTED.
5. ALL DIMENSIONS ARE IN INCHES.

SHOP COPY
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SUBMIT TO
QUALITY CONTROL

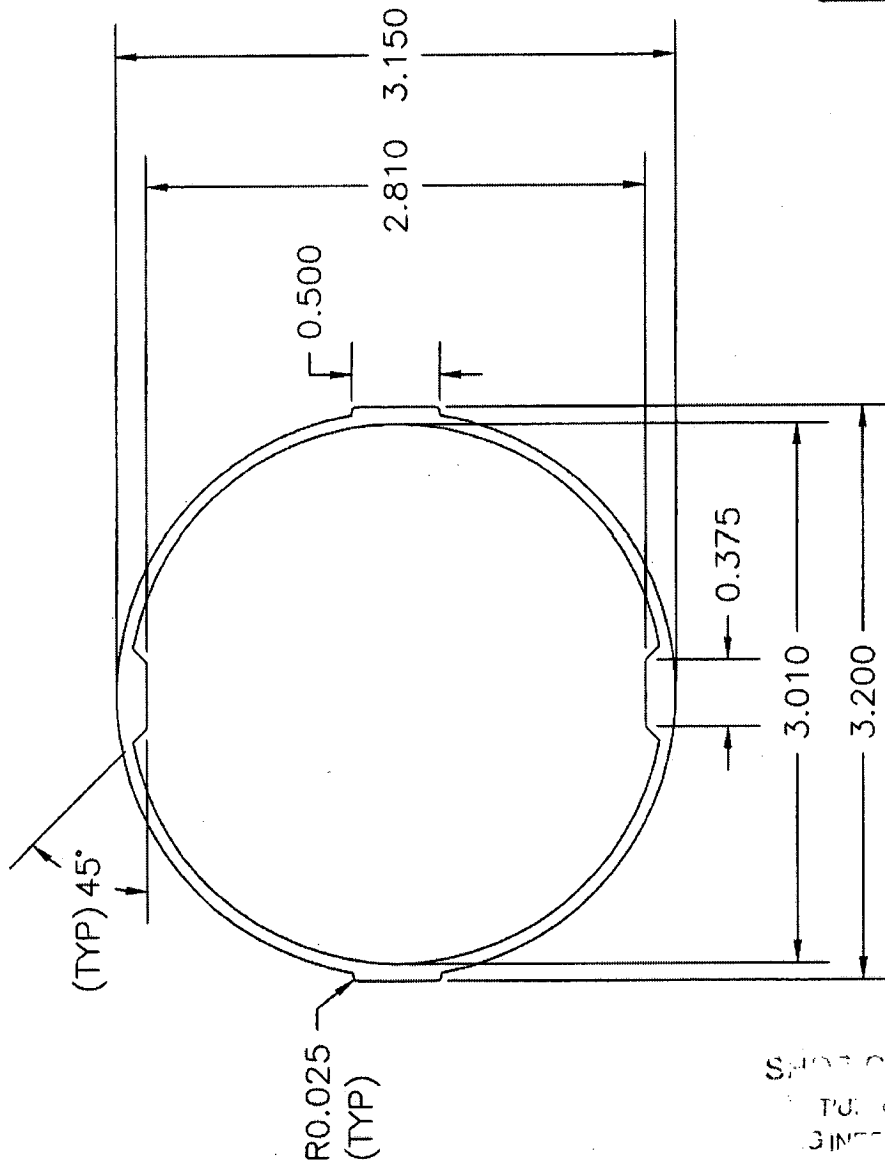
WORK ORDER

NO. 24508



DESIGN <i>DP</i>	DRAWN BY <i>DP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>DP</i>	DRAWING NO. D2600	REV. D SHEET 2 OF 5
DATE 98.08.20		TITLE EXTRUSION	SCALE 1:1

RELEASED
98.8.25 DS



D2600-1

MANUFACTURED WITH CARADON INDALEX DIE # MH-18870
OR BON L DIE # 897121 (PREFERRED CHOICE)
PART NUMBER IS D2600-1-XXX WHERE XXX IS CUT LENGTH IN INCHES (EG. D2600-1-160 IS 160" LONG)



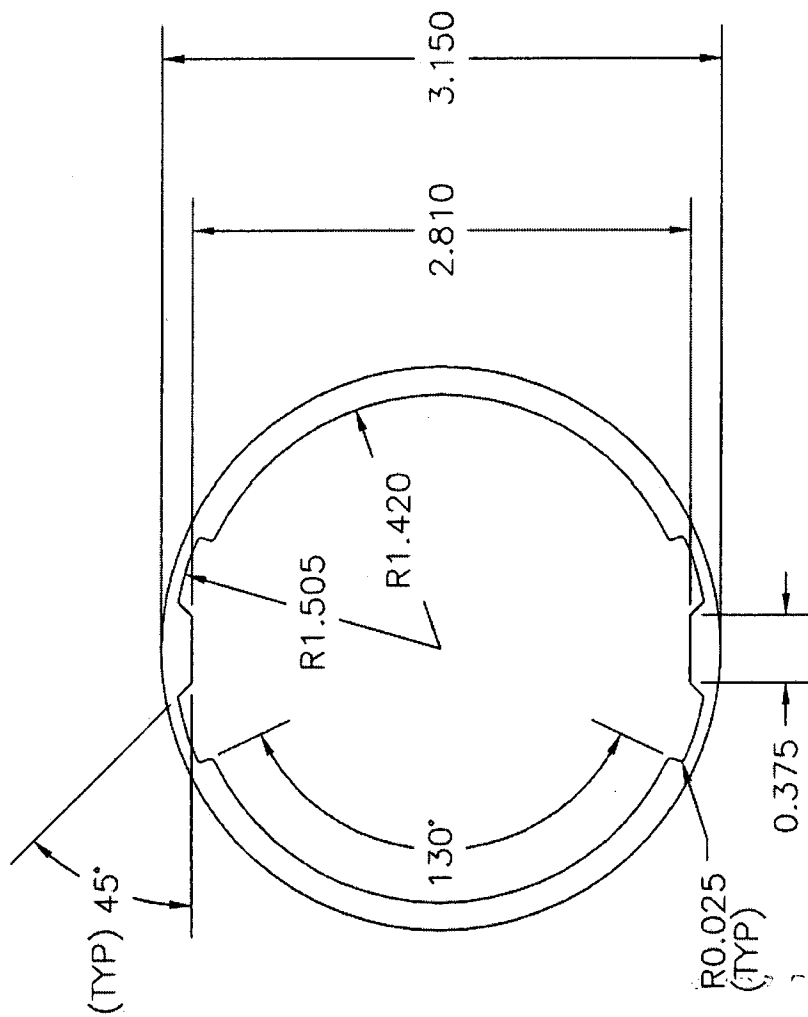
SHOOTING
PUBLISHED
SINCE
U.S. IF
S.E. F. A. A. A. A.
NOTICE

WORK ORDER
NO. 24508



DESIGN <i>DIA</i>	DRAWN BY <i>DIA</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>SA</i>	DRAWING NO. D2600	REV. D SHEET 3 OF 5
DATE 98.08.20		TITLE EXTRUSION	SCALE 1:1

RELEASED
98.8.25 DS



D2600-3

MANUFACTURED WITH CARADON INDALEX DIE # MH-18859

OR BON L DIE # 897122 (PREFERRED CHOICE)

PART NUMBER IS D2600-3-XXX WHERE XXX IS CUT LENGTH IN INCHES (EG. D2600-3-120 IS 120" LONG)

REVISIONS

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WORK ORDER

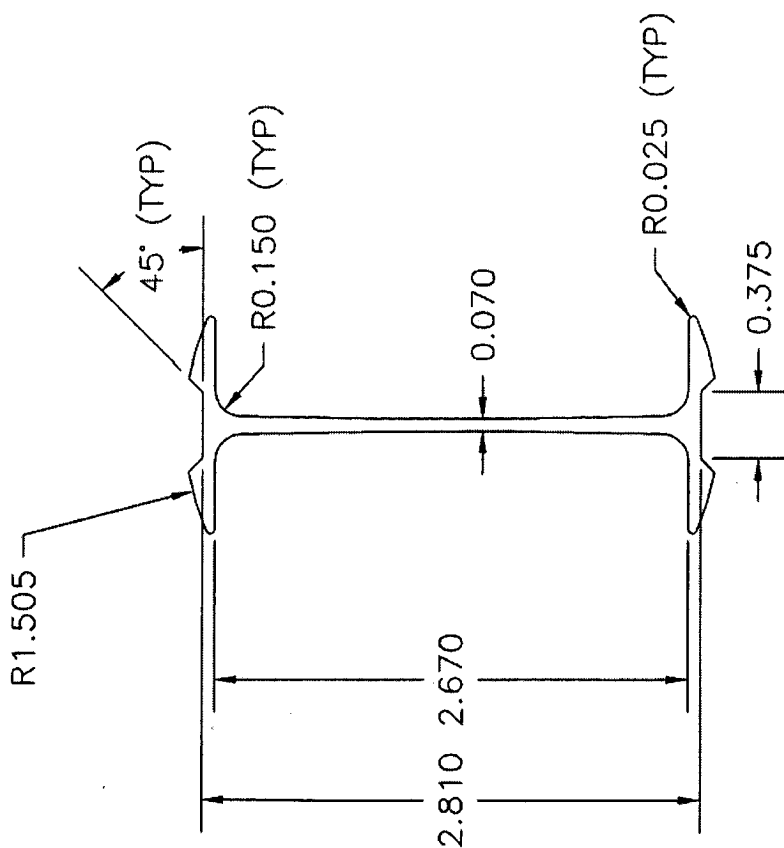
NO. 24508





DESIGN <i>WJ</i>	DRAWN BY <i>WJ</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>KE</i>	DRAWING NO. D2600	REV. D SHEET 4 OF 5
DATE 98.08.20		TITLE EXTRUSION	SCALE 1:1

RELEASED
98.8.25. BS



D2600-5

MANUFACTURED WITH CARADON INDALEX DIE # MS-18871
PART NUMBER IS D2600-5-XXX WHERE XXX IS CUT LENGTH IN INCHES
(EG. D2600-5-108 IS 108" LONG)

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WORK ORDER

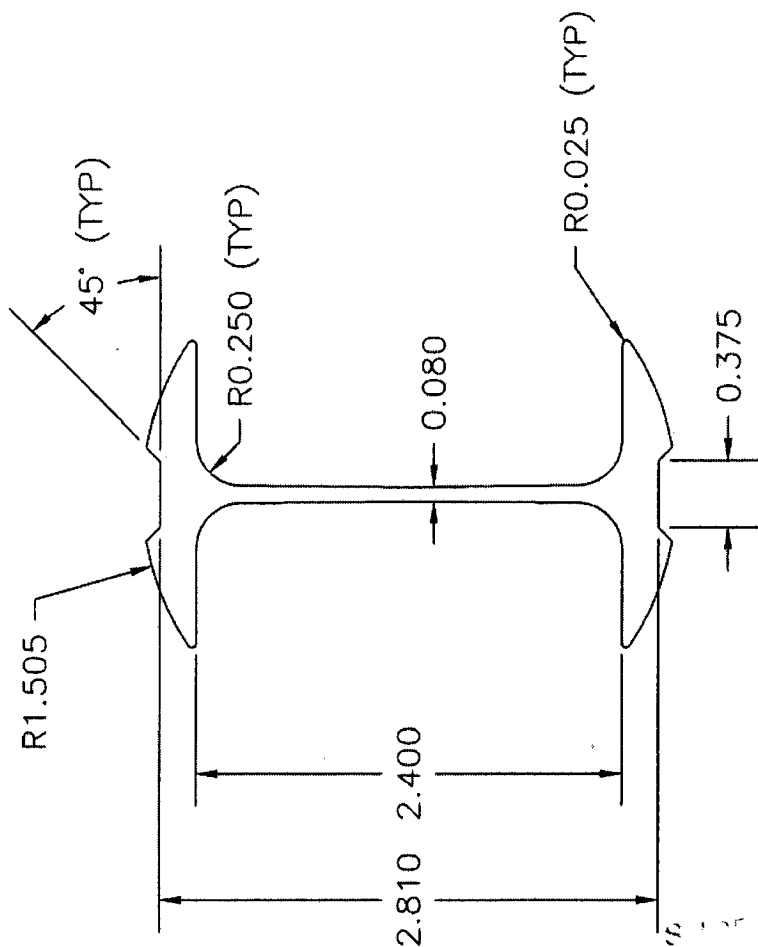
NO. 24508





DESIGN <i>RA</i>	DRAWN BY <i>RA</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>AS</i>	DRAWING NO. D2600	REV. D SHEET 5 OF 5
DATE 98.08.20		TITLE EXTRUSION	SCALE 1:1

RELEASED
98.8.25 DS



D2600-7

MANUFACTURED WITH CARADON INDALEX DIE # MS-18872
PART NUMBER IS D2600-7-XXX WHERE XXX IS CUT LENGTH IN INCHES
(EG. D2600-7-125 IS 125" LONG)

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WORK ORDER
NO. 24508



Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Oct 11, 2005
07:41 am

Work Order No : 0024508
Project Name : D2600-1-160
Project For : WK544
Work Order Type : Main
Main WO Number :
House Part Number : D2600-1-160
Description : Extrusion Round 3" 206
Manufactured : Yes
Amount Req'd : 160
Amount Done : 0
Start Date : 10-08-05
Est Finish Date : 11-05-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00

Order Entry No :
OE Value : 0.00

Est Mark Up : 0.000%
Actual Mark Up : 0.000%

\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
=====					
Burden :	0.00	0.00	0.00		
=====					
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00



CERTIFICATE OF COMPLIANCE

BON L CANADA INC

500 EDWARD AVENUE
RICHMOND HILL, ON L4C 4Y9

Cert Date	Cert No	Sales Order	Page
10/28/05	129693	73065	1
Cust PO	B/L No	Lot	Date
2008805	00282779	73065010	10/28/05

Sold To	Ship To
46024 DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7	46024 DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON

Item No	Part No	Item Description	Cust Part
1.000	DAA-897121-1	160" Mill 6061 T6	D2600-1-160
Gross Weight	2639 LBS		
Net Qty	2,418 LB	171 PC	2280 FT 4 PKG

Specification	Die Desc
AMS-QQ-A-200/8 & ASTM B221-00	

Mechanical Tests:

Test No.	Tensile MPA / KSI	Yield MPA / KSI	%Elongation	Conductivity	Bend/ Drift HR-E
1	303.5 / 44.0	261.4 / 37.9	10.9	.0	91
2	310.4 / 45.0	283.5 / 41.1	10.0	.0	91

Chemical Analysis:

SI	FE	CU	MN	MG	CR	NI	ZN	GA	V	TI	ZR	OTHER
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.665 .240 .254 .028 .910 .054 .000 .079 .000 .009 .013 .000 .000

This will certify that the material described herein has been inspected and tested in accordance with Bon L Canada's standard sampling and testing procedures or in accordance with the requirements of any specifications forming a part of the material description to the extent indicated herein. Data of chemical composition for the material and test results from samples representative of the material are set forth above hereof or in any attachments hereto. This information shows that the material meets the applicable requirements. Inspection and test records are maintained on file. This certificate shall be deemed apart of and subject to the terms and conditions of warranty set forth on the reverse side of our order acknowledgement form. No other warranties are applicable.

Paul Dailleboust, QA Manager Signed for Bon L Canada

15-12-15